IN THE SUBSTITUTE SPECIFICATION

Please cancel paragraphs 032, 033, 034, 041 and 047 of the Substitute Specification which was submitted as part of the Preliminary Amendment filed with the application. Please substitute replacement paragraphs 032, 033, 034, 041 and 047, as follows:

[032] Fig. 2 schematically shows a chronological progression of, for example, the tension S1 without the present method being utilized. As soon as the glue spot 26 passes through the draw-in unit 03, a steep rise of the tension S1 starts, and progresses as far as the entry of the glue spot 26 into the hopper inlet. The same progression applies for the course of the tension S0, but is chronologically offset slightly toward the "front", i.e. to the left in Fig. 2. Thereafter, the tension S1 is on a level which is increased by an amount Δ ~~Delta]~~S1 and decreases only slowly. The increased levels of the tensions S0, S1, etc., deviating, in particular, with a large amplitude from the reference variable S0- soll, S1-soll, causes registration errors between the printing groups 16 to 19 because of the change in the stretching behavior of the web 01.

[033] Now, in a first preferred ~~exemplary]~~ embodiment of the present invention, as depicted in Fig. 3, these registration errors are avoided, or are reduced, in that the reference variable S0-soll of the web tension S0 i s reduced by the amount Δ S-soll. This predetermined amount Δ S-soll can advantageously be changed and corresponds, for example, to a mean empirical value of the expected increase, without an appropriate reduction, of the tension S0 by the amount Δ S0. In particular, the amount Δ S0 can be

selected in such a way that after the reduction of the tension S0 resulting from the change of the reference variable S0-soll, the tension S0 initially swings below the original reference variable S0-soll, S1-soll and, following a pass through of the interference, the reference variable S0-soll, S1-soll, swings above the reference variable S0-soll, S1-soll, wherein the respective absolute deviation at the minimum or maximum from the original reference variable S0-soll, S1-soll is considerable in contrast to the resulting deviation without the reduction. The tension S0, S1 fluctuates with a clearly reduced amplitude around the original reference variable S0-soll, S1-soll. This amount Δ S-soll can be stored, for example, in a memory unit 23 or determined in a computing unit 23 which is depicted in Fig. 1. In the case where the changes in the tensions S0 and S1 are of the same size, this size can correspond to the amount Δ S1, represented only as an example of the tension S1 in Fig. 2 or, as described above, to a portion of this amount Δ S1. However, it can also be determined by a chronological progression of the tension S0 corresponding to Fig. 2, or in other ways, for example by tests.

[034] The chronological progression of the reference variable S0-soll is schematically applied in Fig. 3, parallel with the tension S0 or S1 shown in Fig. 2. In the course of the passage of the glue spot 26 through the draw-in unit 03, or slightly prior to that passage and in particular shortly before the actuation of a severing blade, or at that time at the latest, the reference variable S0-soll is reduced. This can take place in a single step, or can take place continuously, for example in the form of a ramp, or can take place in several stages, as represented in Fig. 3. In the present embodiment, as depicted in Fig.

3, the reference variable S0-soll is not reduced in one step, but is reduced in a plurality of steps during a time interval Δ t, which time interval can be determined from empirical values, or in particular from the running time of the web 01 from the draw-in unit 03 to the hopper inlet roller 12. In one embodiment, the reference variable S0-soll, reduced in the end by the amount Δ S-soll, can be maintained over a time interval Δ t′, as seen in Fig. 3, past the time of the maximum of the tension S1, as seen in Fig. 2, which would be expected without the reduction, before the reference variable S0-soll is returned, either in one step, or continuously, or in a plurality of smaller steps, back to the reference variable S0-soll desired for the printing press status. The "normal" tension regulation, if provided, then again takes over the regulation of the tensions S0, S1 and is responsible for this regulation. In a second preferred embodiment of the present invention, as depicted in Fig. 4, the reference variable S0-soll is not reduced by a fixed amount Δ S-soll, but is temporarily reduced to a fixed new value S0-fix, which can be predetermined and/or changed. For example, by use~~means~~] of this method, it can be assured that the tension S0 upstream of the printing unit 04 does not drop so far that the tension S1 downstream of the printing unit 04 falls into a range which is critical for the web run, for example below 8 daN/m.

[041] An example of a possible control circuit for regulating the tension S0 is schematically integrated in Fig. 1. In a conventional control circuit, the regulating unit 22 makes sure that the tensions S0, S1 are each maintained at the desired reference variable S0-soll, S1-soll. For this purpose, actual values <u>of tensions</u> S0[[-ist]], S1[[-ist]] are provided as input values, are compared with the reference variables S0-soll, S1-

soll, and appropriate drive mechanisms are set by the use of appropriate output values. For example, the reference variables S0-soll, S1-soll can be provided by a printing press control device 24, or can be formed in the regulating unit 22 itself from values g, which values g define the printing press status, in the regulating unit 22.

[047] The return can be based, for example, on a continuous or on discontinuous measured value pick-up wherein, however, a reference variable S0-$soll_m$, which is valid for the next time interval Δt_m~~m~~, is determined in defined, possibly selectable, time intervals Δt_m by use of the measured value, and is supplied to the regulating device. A stepped return of the reference variable S0-soll resulting from this is represented, by way of example, in Fig. 5. However, the return to the original reference variable S0-soll or to a new fixed reference variable S0-soll' can also be determined in another way by use of the measured values S1-ist and can be preset. Thus it is possible, for example, to determine a slope of partial ramps in sections from two or from several measured values, wherein then the ramp represented in Fig. 4 can have different slopes in sections as a function of the measured values.